






# Work Order ID 56512



February 25, 2010 1:03:12 PM



Page 1


Item ID: D4007-3 Accept  Setup Start   
 Revision ID: Stop   
 Item Name: Support  
 Start Date: 2/25/10 Start Qty: 4.00  Cust Item ID:  
 Required Date: 3/17/10 Req'd Qty: 4.00  Customer:

Reference:


Approvals: Process Plan: 11 Date: 10-2-25 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4007	<u>A PRELIM</u>								

100		<u>Issue to to</u>	0.00						
Waterjet	<u>RG</u>	<u>GFI</u>	0.00						
FLOW CNC Waterjet									

Memo  
 1-Cut as per Dwg  
 Dwg Rev: \_\_\_\_\_  
 Prog Rev: \_\_\_\_\_  
 2-Deburr if necessary

110			0.00						
QC	<u>RG</u>		0.00						
Quality Control									

Memo  
 Receive & Inspect for forward damage  
 Ensure Col Attached

**PRELIMINARY ISSUE**

PO 11414 (4) BT 10-2-25

# Work Order ID 56512

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Item ID: D4007-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 2/25/10 Start Qty: 4.00



Cust Item ID:

Required Date: 3/17/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

~~QC8-Inspect parts - second check~~

*QC6 inspect parts + mat. certs.*

Memo

*Swales/23 to polemday only*



0.00

0.00

**QC APPROVAL**

130



Brake NC

Brake NC

Bend as per dwg

Memo

0.00

0.00

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

# Work Order ID 56512

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Page 3

Item ID: D4007-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 2/25/10 Start Qty: 4.00



Cust Item ID:

Required Date: 3/17/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

Quality Control

170

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

X4 BB 10/06/14

10/06/15

10-6-15

POSITIVE RECALL

AUTH

DATE 10.06.10

# Picklist Print

Page 1

February 25, 2010 1:03:17 PM

Work Order ID: 56512



Parent Item: D4007-3



Parent Item Name: Support

Start Date: 2/25/10

Required Date: 3/17/10

Comments: IPP rev A 09.12.18 new Issue Prelim EC verified: DD

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M2024T3S.063

Purchased

No

100

sf

146.1602

1.3263



2024-T3.063 sheet

D4007-3P-56512

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

146.1601505

105916

1.09

110980

5.4854

111787

12.2847505

113866

69.3

113867

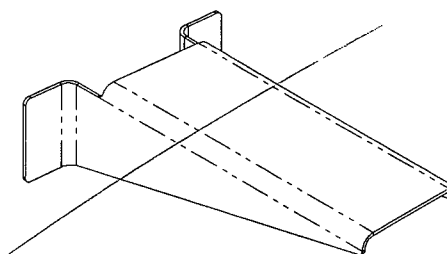
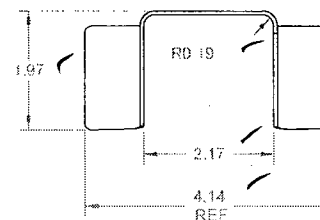
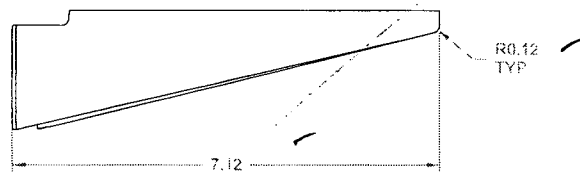
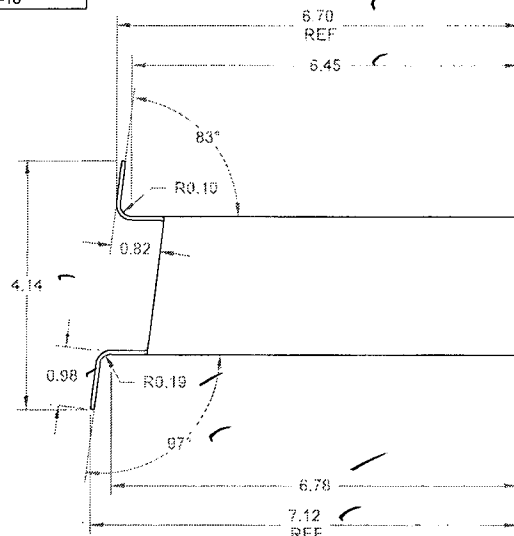
56

19059

2

u

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4007-3	JCA-M47-2-18



See Rev. A

PRELIMINARY ISSUE

# **D4007-3 TOP SUPPORT BRACKET**

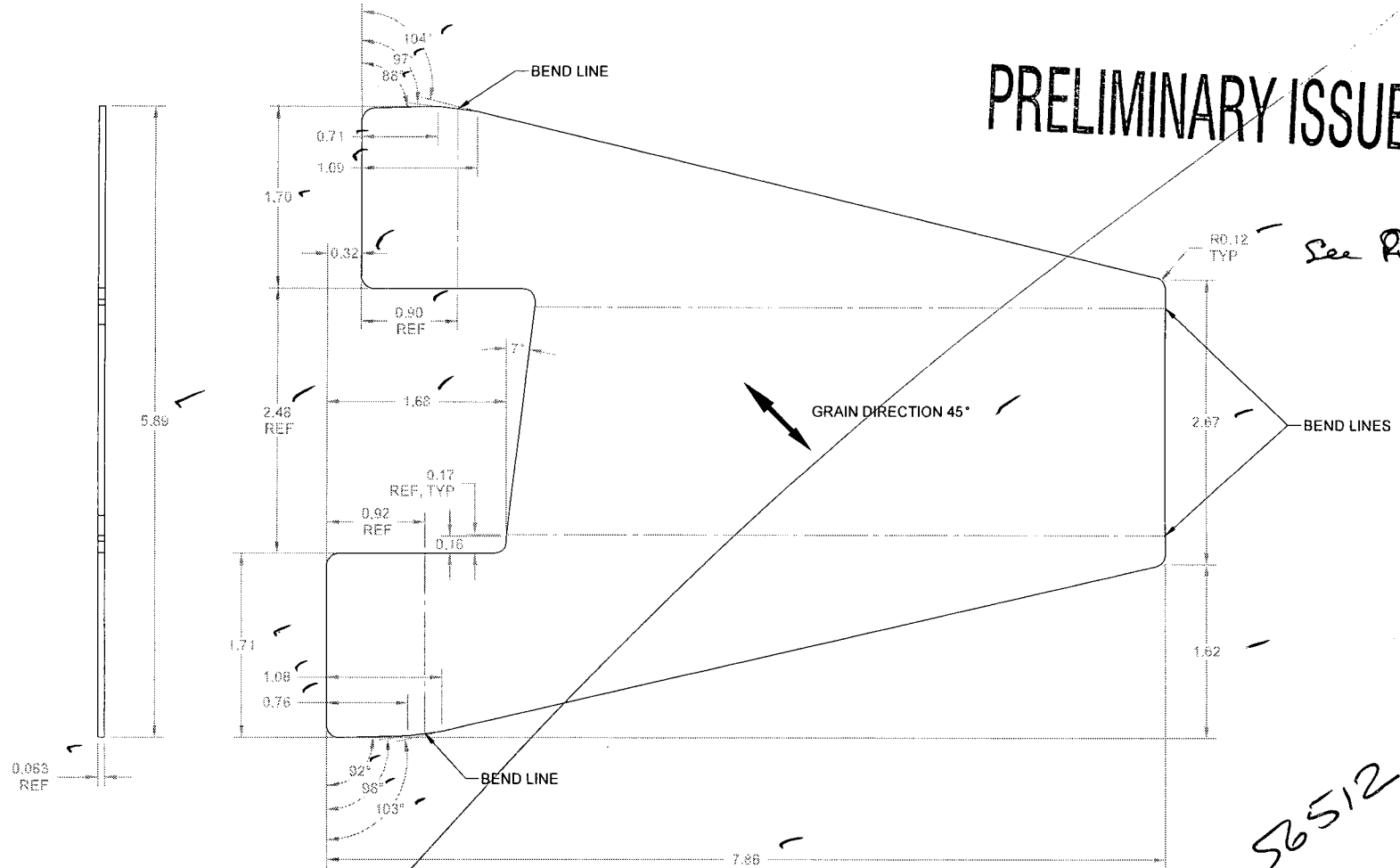
## **NOTES:**

- 1) MATERIAL: MADE FROM D4007-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4007-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.19 lbs

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4007</b>	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		<b>SUPPORT</b>	NTS
DATE	10.02.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

56512

# PRELIMINARY ISSUE



**D4007-3F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037 OR ASTM B209  
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4007</b>	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>SUPPORT</b>	NTS
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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO11416

Purchase Order Date 2/24/10

PO Print Date 2/24/10

Page Number 1 of 1

Order From :

VC-GFI001

GFI  
180 AVENUE LABROSSE  
POINTE CLAIRE, QC H9R 1A1  
CA

Contact Name

Vendor Phone

514 630 4877

Vendor Fax

514 630 4849

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D4005-3P	Fwd Restaint Beam	2/25/10 3/12 Yes	4.00 Each	Purolator ground	\$99.0000	\$396.00
Special Inst:			As per DWG: D4005 Rev: PA1 B# 55835				
2	D4007-1P	Support	2/25/10 3/12 Yes	4.00 Each	Purolator ground	\$80.0000	\$320.00
Special Inst:			As per DWG: D4007 Rev: PA1 B#56460				

PO Total:

\$716.00

PO Instructions:

GFI QUOTE# GFI 2087

Change Nbr:

1

Change Date: 2/24/10

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable



180 AVENUE LABROSSE  
POINT-CLAIRE, QC, CANADA H9R 1A1  
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

Il est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



# BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON	PAGE
JR - DY	MO. - MO.	AN. - YR	SHIPPING MEMO NO.	
16	03	10	0434430	1/1



NDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

CODE DE CLIENT	N° DE CONTRAT	VOTRE N° DE COMMANDE	EXPÉDIÉ PAR
CUSTOMER CODE	JOB NO.	YOUR PURCHASE ORDER NO.	SHIP VIA
DART	GFI-0299	0211141	PO11416

QUANTITÉ	N° DE PIÈCE	DESCRIPTION
QUANTITY	PART NO.	

4 D4007-3P

SUPPORT

CERTIFICATE OF CONFORMANCE REQ.

MFG. JOB# JO211141-001 QTY 4



*OK*

EXPÉDITEUR  
SHIPPER

N° DE BON DE LIVRAISON  
SHIPPING MEMO NO.





CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

8/6/23

CERTIFICATE NO.	<u>1</u>	OUR JOB NO	<u>J0211141</u>	SHIPPING MEMO	<u>0434430</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>—</u>	<u>4 PCS</u>	<u>PO11416</u>	<u>D4007-3P</u>		<u>SUPPORT</u>	<u>PA1</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>AL 2024-T3</u>		<u>SAMUEL / KAISER ALUMINUM</u>		<u>419327A2</u>		
PROCESS			PROCESSOR		RELEASE NOTE #	
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>			<u>GFI</u>	<u>CONFORMS</u>	
2	<u>REF. GFI MANUFACTURING JOB NUMBER J0211141-001 (4 PCS)</u>					
3						
4						
5						
6						
7						
8						
9						

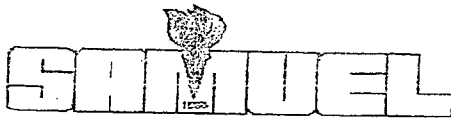
WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 17 MARCH 2010

G.F.I. Q.C. REP.

B. Samei





LES METAUX SPECIALISES SAMUEL  
21525 CLARK-GRAHAM  
BAIE D'URFE, QUEBEC, CANADA  
H9X 3T5

No 001468863



(514) 457-3399

FAX (514) 457-9393

PAGE 1 DE/OF 1

TRANSPORTEUR/CARRIER NAME  
CASTERO TRANSPORT

CAMION/TRUCK  
099

NOM DE LA BRANCHE/SALES BRANCH NAME  
LES METAUX SPECIALISES SAMUEL

DATE D'EXPIRATION/EXPIRATION DATE  
9/14/09

**VENDU À/SOLD TO:**

GFI DIVISION OF THOMAS & BETTS, LIMITED  
180 AVENUE LABROSSE  
POINTE CLAIRE  
POINTE-CLAIRE  
QC  
H9R1A1 (514) 630-4877

**EXPÉDIÉ À/SHIP TO: TÀB: DEST**

G.F.I. INC  
180 AVENUE LABROSSE  
POINTE-CLAIRE  
QC  
H9R1A1 CA (210678-00001)

N° COMMANDE  
N° ITEM  
489556-01

DESCRIPTION ET POIDS/DESCRIPTION AND WEIGHT

#Comm du client: 0075894

1 PCS FEUILLES ALUMINIUM 2024 T3

.0630"x48"x144"

QQA250/4 BARE

Cert/Test: TRUCK  
43 LVR

Description	Art	Pd ca	Qté	#Étiq	Vendeur
#Étiq mln	#À soul			Étiq princ	#Coul
1297052	1	48.000	43	4564255	017
Total:	1	48.000	43	D851930	19327A2

Poids total:

#Total paquets: 1

43 LVR

Commentaires connaissance:

CERTIFICAT DE CONFORMITÉ  
LE MATÉRIEL DÉTAILLÉ CI-DESSUS EST CERTIFIÉ  
CONFORME AUX EXIGENCES DE VOTRE COMMANDE ET AUX  
SPÉCIFICATIONS DES NORMES DU GRADE. SVP VOUS  
RÉFÉREZ AUX CERTIFICATS CI-JOINTS. AUTORISÉ PAR:

DATE 11-2-09  
PAM BOOTH  
ADMINISTRATION  
INSPECTION  
7  
SAMUEL

NIR: R-539477-1

PRÉPAYÉ PAR CHARGES	<input checked="" type="checkbox"/> PORT PAYÉ/PREPAID	<input type="checkbox"/> PORT DÙ/COLLECT	INST. VOITURIER/DRIVER INSTRUCTIONS	REÇU PAR/RECEIVED BY
EXPÉDITEUR/DISPATCHER			VOITURIER/DRIVER	

1. ORIGINAL - NON NÉGOCIABLE (CE CONNAILLEMENT DOIT ÊTRE SIGNÉ PAR L'EXPÉDITEUR ET LE VOITURIER)

SHIP TO: SAMUEL BAIE D'URFE 21525 CLARK-GRAHAM BAIE D'URFE, PQ, CA H9X3T5
SOLD TO: SAMUEL LAVAL 2225 FRANCIS HUGHES LAVAL, PQ, CA H7S1N5

# KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

## CERTIFIED TEST REPORT

Serial Number  
4146676

CUSTOMER PO NUMBER: N21479		WORK PACKAGE:	CUSTOMER PART NUMBER:		SHIP RUN/LOAD ID: 101411/2	GOVT CONTRACT NUMBER:
KAISER ORDER NO: 1074833	LINE ITEM: 3	SHIP DATE: 11-NOV-2008	ALLOY: 2024	CLAD: BARE	TEMPER: T3	PRODUCT DESCRIPTION: MILL FINISH SHEET
WEIGHT SHIPPED: 3180 LB	QUANTITY: 71 PCS EST.	B/L NUMBER: 2020211	GAGE: 0.0630 IN	WIDTH: 48.000 IN	LENGTH: 144.000 IN	

### Certified Specifications

AMS 4037/RevN  
CMMP 019/RevD

AMS-QQ-A-250/4/RevA  
CMMP 025/RevR

ASTM B 209/Rev07

Test Code: 1504

### Test Results

Lot: 419327A2 Cast 443

Drop 13

Ingot 3

S. 10/23

(ASTM E8/B557)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	67.4 : 67.6 (465 : 466)	45.0 : 45.1 (310 : 311)	17.1 : 19.0

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.09	0.25	4.4	0.58	1.3	0.01	0.12	0.02	0.01	0.01	TOT 0.03

### ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.8	0.30	1.2	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.9	0.9	1.8	0.10	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

### TEST NOTES

2024-T351 plate 3.001-4.000" thick, if ultrasonically inspected, meets requirements of CMMP025 per SDR CMMP025-KaiserT-2.

# KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586

## CERTIFIED TEST REPORT

Serial Number  
4146676

### CERTIFICATION

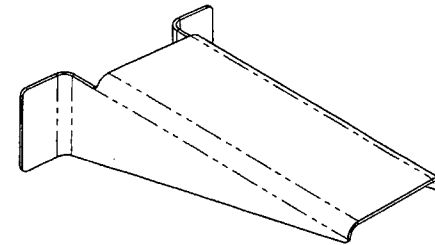
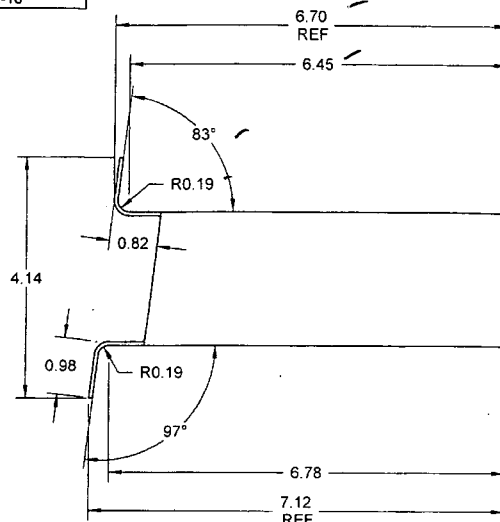
KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE U.S.A OR CANADA AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR

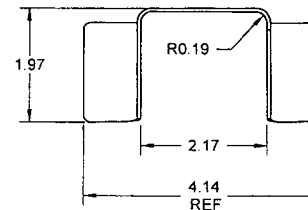
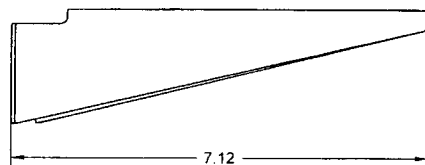


DART AEROSPACE  
PART NUMBER  
D4007-3

JOHN CAMERON AVIATION  
PART NUMBER  
JCA-M47-2-18



W/D 56512



# **D4007-3 TOP SUPPORT BRACKET**

RELEASED  
2010-05-05  
MD

## **NOTES:**

- 1) MATERIAL: MADE FROM D4007-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4007-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.19 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4007	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT	NTS
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